



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE703A95-0508-00-1

Job Sheet 170629



Part No: RBE703A95-0508-00-1

Job Qty: 6 ea

Part Name: Quill



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/13/18	0.00	0.00	Start Up Machining-4		3L 18-2-6
110	CNC Lathe	6 pcs		2/14/18	0.00	6.00	MORI SL-154		JK
120	QC	6 pcs		2/14/18	0.00	0.00	QC2		JK
130	QC	6 pcs		2/14/18	0.00	0.00	QC8		FK 18-2-6
140	QC	6 pcs		2/14/18	0.00	0.00	QC5		38
150	Outsource	6 pcs		2/27/18			ATG001-VC	Outsource 10/1	AT 18-2-6
160	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging2		APAS 18-2-6
170	QC	6 pcs		2/27/18	0.00	0.00	QC6		11 38
180	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging3		DA 89 9-89
190	QC21-SA	6 Ea		2/27/18	0.00	0.00	QC21		21 FEB 2 2018

Part Op 110 - 1-Machine as per DWG. FB651 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 140 - Engrave T/N (RBW6405G08732-3G) And S/N number Using Marktronic engraver as per DWG.
150 - Issue P/O to ATG : PO 039040 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0508-00 Rev 5C

FEB 14 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.125	6061 Round Bar 1.125	2.1000 ft (.35 ea)	90-Start up Operation	
	FM13C070-1	2.09		

Part Specifications

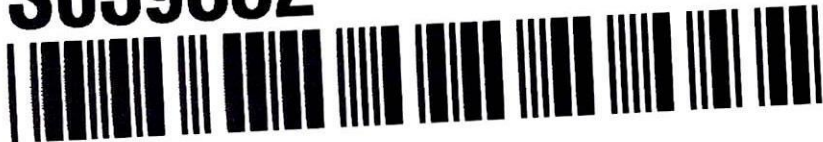
Specifications could not be found.

Plex 1/17/18 11:41 AM Dart.lajeunesse.marie



S039332

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Quill

PART NO: RBE703A95-0508-00-1

Original Serial #: S039332

Revision:

Operation:

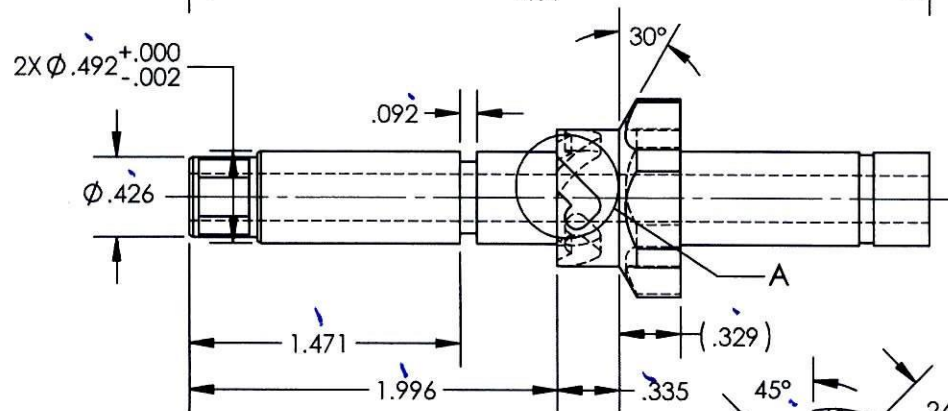
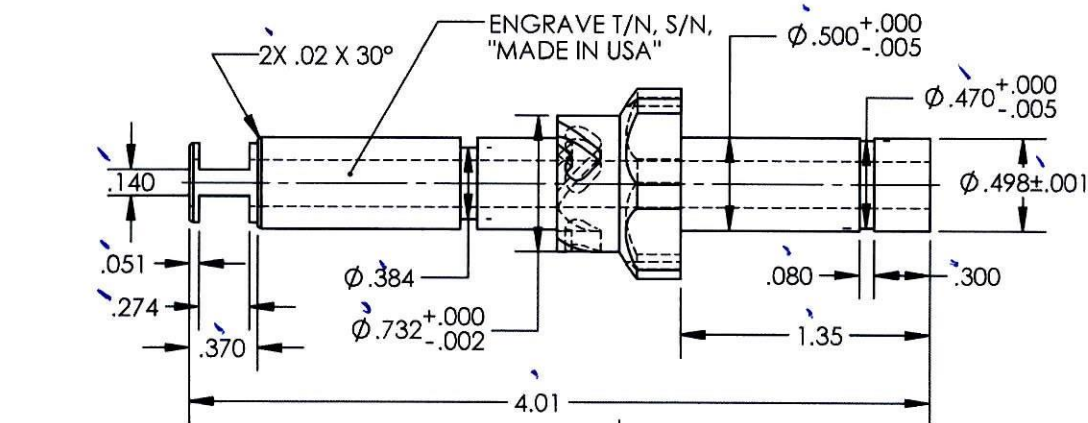
Change No:

Start up Operation 02/06/18

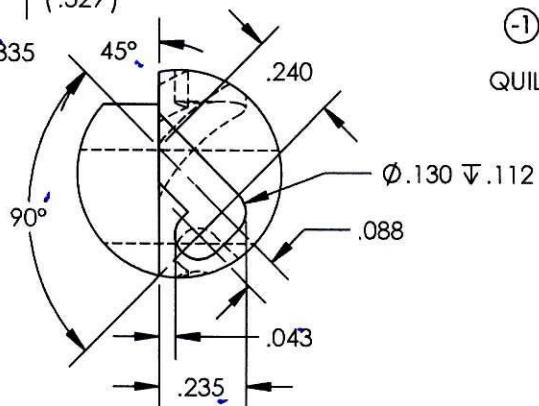
Job No: 170629

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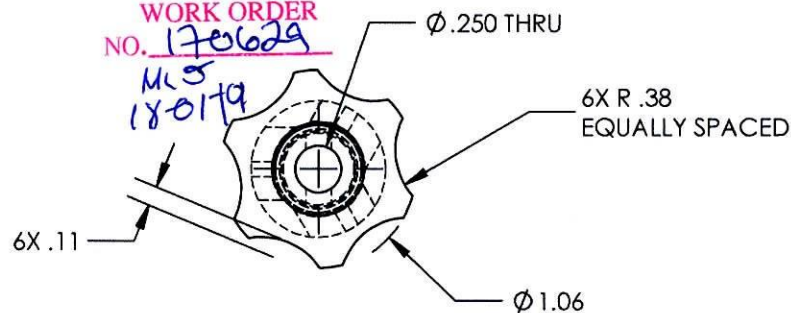
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D O-RING FROM $\varnothing 13\text{mm}$ OD x 1.75mm cross section. ADDED NOTES, CH'D SLOTS FROM 90° @ $\varnothing .131$, AND ID FROM $\varnothing .230$	5/28/2009	WP
2	CH'D ID FROM $\varnothing .256$ THRU. CH'D SLOTS FROM 60° @ $\varnothing .125$ ON HELIX PER G.E.	11/4/2009	RJC
2A	DELETED 20.2" REF. DIMENSION PER G.E.	12/16/2010	RJC
3	CH'D STEM LENGHT FROM .800 TO 1.35, DELETED BARB, ADDED GROOVE	7/31/2012	JAG
4	CH'D 8X R.156 & 8X .12 TO 6X R.375 & 6X .106.	4/17/2013	CFS
5	-1 CH'D DIMS WAS 6X .106 IS 6X .11, WAS 6X R .375 IS 6X R .38.	6/19/2013	BIM



DETAIL A
SCALE 2:1
3X EQUALLY SPACED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170629
MCS
180179



①
QUILL

RED BARN MACHINE	
TITLE MGB DRAIN TUBE	
DWG NO. RBE703A95-0508-00-1	REV 5C
MAT'L 6061 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .xxx ± .005 FRACTIONS ± 1/32 .xx ± .01 ANGLES ± 5° .x ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: PERRITT APPROVED <i>D Weil</i> HEAT TREAT FINISH RED ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II USED ON MODEL AS350, EC130
SCALE 1:1	DATE 11/12/2008 SHEET 2 OF 2

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

 Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order:	170629
Description: Quill		Part Number:	RBE703A95-0508-00-1
Inspection Dwg: RBE703A95-0508-00-1		Rev: 5C	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.140	±.005	.141	/		vern	SL-1
.051	±.005	.051	/			
.274	±.005	.273	/			
.370	±.005	.370	/			
.384	±.005	.384	/			
.732	+0 -.002	.731	/			
4.01	±.01	4.011	/			
1.35	±.01	1.350	/			
.080	±.005	.079	/			
.300	±.005	.300	/			
.498	±.001	.499	/		mic	SL-4
.470	+0 -.005	.468	/		vern	
.500	+0 -.005	.499	/		mic	
.492	+0 -.002	.491	/		mic	
.426	±.005	.426	/		vern	
1.471	±.005	1.471	/			
1.996	±.005	1.996	/			
.335	±.005	.335	/			
.329	±.005	.330	/			
.092	±.005	.092	/			
φ.250	±.005	.252	/			
.11	±.01	.108	/			
1.06	±.01	1.063	/			
2.38	±.01	2.380	/			
.235	±.005	.235	/			
.043	±.005	.044	/			
.130 ±.112	±.005	.128 ±.113	/			
.240	±.005	.240	/			

Measured by:	SL	Checked by:	F.K	QC Inspector:	
Date:	18-2-6	Date:	18-2-6	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



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Canada

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PURCHASE ORDER

PO039040

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
11	170612	RBE350A94-3700-C-05	As Per Dwg RBWSI-HT-12AS-1 Rev. E -Certificate of Conformity is required Bottom -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A94-3700-C-05 Rev. 6 -Certificate of Conformity is required	Firmed	2/21/18	18 pcs	0 pcs	18 pcs	\$5.13/pcs	\$92.34
12	170629	RBE703A95-0508-00-1	Quill -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0508-00 Rev 5C	Firmed	2/21/18	6 pcs	0 pcs	6 pcs	\$5.13/pcs	\$30.78
13	171659	T-8812187000	Drain Tool -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As per Dwg 8812187000 -Certificate of Conformity is required	Firmed	2/21/18	4 pcs	0 pcs	4 pcs	\$6.61/pcs	\$26.44
									Grand Total: \$1,144.88	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

CL



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914652

Date: 22-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Anodize per MIL-A-8625F, Type II, Class 2, red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22550 PO: PO039040 Line: 9		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>22/2/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914652

Date: 22-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: RBWSI-HT-12AS-1 Top Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22551		Rev: E PO: PO039040 Line: 10
18 ea	Part: RBE350A94-3700-C-05 Bottom Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22552		Rev: 6 PO: PO039040 Line: 11
6 ea	Part: RBE703A95-0508-00-1 Quill Anodize per MIL-A-8625F, Type II, Class 2, Color, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22553		Rev: 5C PO: PO039040 Line: 12
4 ea	Part: T-8812187000 Drain Tool Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22554		Rev: PO: PO039040 Line: 13
22 ea	Part: RBE350A94-3701-00 Main Rotor Rigging Tool Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22549		Rev: 2A PO: PO039040 Line: 8
13 ea	Part: RBT18713-1 Body		Rev: 4

DAS
11
J-89

DAS
38
9-89

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